

Work Order ID 56609

March 2, 2010 9:16:51 AM



Page 1

Item ID: D2480-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access Handle Weldment RH

Start Date: 3/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2480

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld as per Template DT 8333 (DT 2480 CJ)

EL 10-330

(X3)
Pho →

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

(3) PD 10.03.31

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/04/01

(X3)
RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2480-012 PAR #: N/A Fault Category: Lge Fab NCR: (Yes) No DQA: 1A Date: 10.04.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>56609</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/3/30</u>	<u>#100</u>	<u>Qty x1 Assembly scrap. D2476</u> <u>welder</u> <u>wrong Duran weldin and</u> <u>welder attempted to straighten</u> <u>and cause a LARGE kink at the</u>	<u>[Signature]</u>	<u>Scrap + Destroy Assembly</u> <u>Qty x1 cancel no replace</u>	<u>EL</u> <u>10-3-30</u>	<u>[Signature]</u> <u>10/04/01</u>	<u>[Signature]</u>	<u>S</u> <u>10/09/30</u>
		<u>Qant A D2476 to D2479.</u> <u>R.C. Process</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>S</u> <u>10/09/30</u>

NOTE: Date & initial all entries

Work Order ID 56609

March 2, 2010 9:16:51 AM

Page 2

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Start Date: 3/02/10 Start Qty: 4.00

Required Date: 3/08/10 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powdercoat

M-11 3170

Memo

0.00

Powder Coating

START TIME:

2:45

3:15

FINISH TIME:

OVEN TEMPERATURE:

400 °F

M-11

10/04/01

3X

140

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Rec'd 4/8 (3)

150

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

PAP
56609

Rec'd 4/8 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56609

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Page 3

Item ID: D2480-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access Handle Weldment RH

Start Date: 3/02/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/12

U 00408

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 2, 2010 9:16:50 AM

Page 1

Work Order ID: 56609

Parent Item: D2480-012

Parent Item Name: Heli-Access Handle Weldment RH




Start Date: 3/02/10

Required Date: 3/08/10

Comments: IPP C1 03.01.09 Added Powder Coat

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2478 		Manufactured	No			100	Each	0.0000	4.0000			
Heli-Access Handle												
D2479 		Manufactured	No			100	Each	0.0000	4.0000			
Heli-Access Handle												
D2481 		Manufactured	No			100	Each	32.0000	8.0000			
Mounting Plate												

B56610 x 4

B56611 x 4

EZ 10-3-29

EZ 10-3-29

EZ 10-3-29

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 32
40634 15
40888 17

8

D2482 Manufactured No 100 Each 68.0000 4.0000



Mounting Plate



EZ 10-3-29

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 68
38319 48
40635 20

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

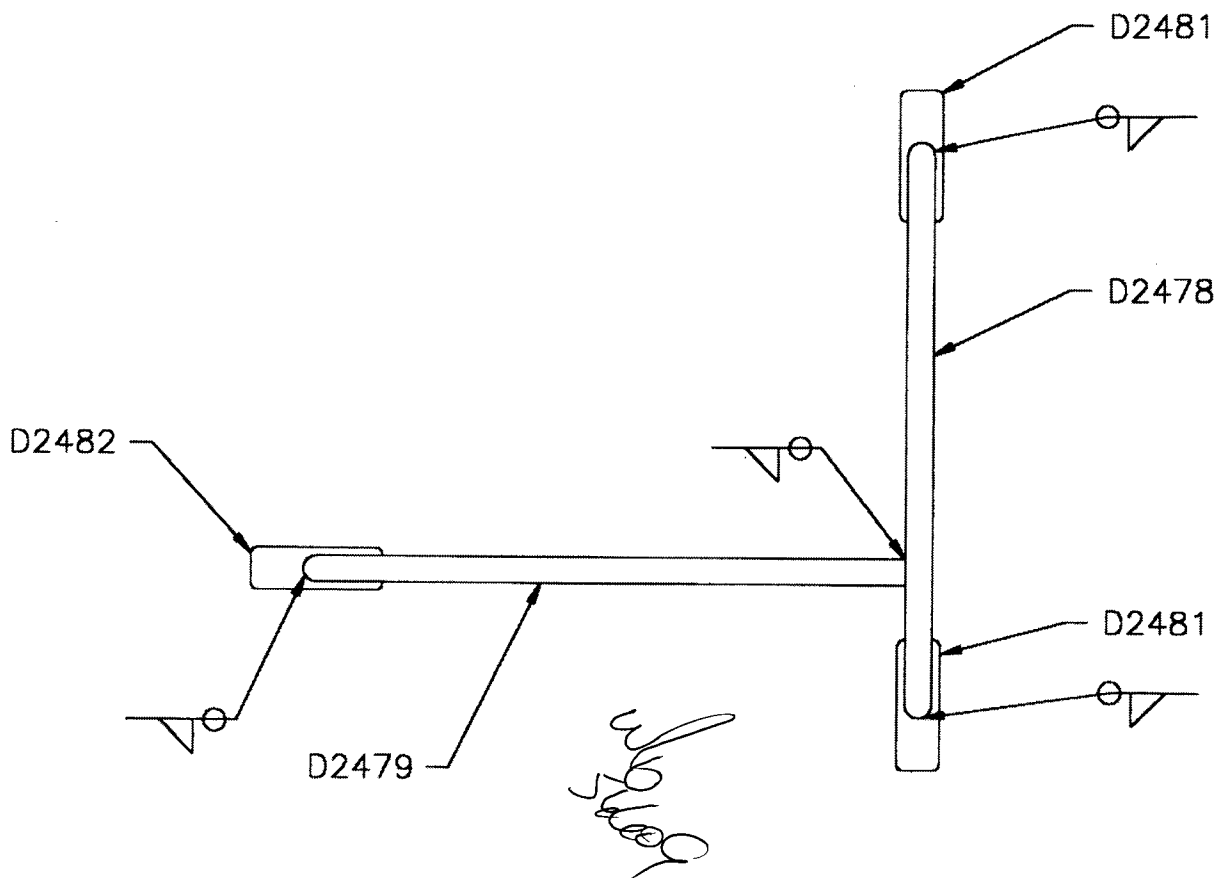
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
- 2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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